

Work Order ID 61765

Thursday, September 02, 2010 11:18:34 AM

Page 1

Item ID: D350-748-101

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Installation, High Fwd

Start Date: 9/2/2010 Start Qty: 1.00

Required Date: 9/20/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-748-141	Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-748-101

CHG001

Sula/31

10-01-28

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

DP

10-11-22

120

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

Quality Control

10-11-22

10

Dart Aerospace Ltd

W/O: 61765		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector	
10.12.09 10.12.09 CP	141	- DEFLECT TUBE TO 3500 ^{lb} FOR 10 SEC. 1 MINUTE - CHECK HEIGHT & WIDTH OF CROSSTUBE.	CP	10.12.09 10.12.09 CP	1	CP 10.12.13 OSI 042	6/2/13	
10.12.09	142	NDT TUBE FOLLOWING DEFLECTION TEST				CP 10.12.13 OSI 042		

Part No: D350-748-101 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125  HandFXtube	Memo ***Stress relief*** Heat treat crosstube as per QSI010 4.3	0.00 0.00	<i>SAD</i> <i>DP</i>						
127  QC	QC5- Inspect part completeness to step on W/O	0.00 0.00							
Quality Control	Memo		<i>Si 10/11/24</i>						<i>10-11-22</i> <i>3pm to 7pm</i> <i>FD</i>

W/O:		WORK ORDER CHANGES					
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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Crosstubes	Crosstubes	0.00							
	Memo	0.00							
	1-Drill Tube as per Dwg D350-748-141 Using DT8876 A,B & C Drill Jigs, Set-up drill table as per QSI 010								
	2-Deburr								
	3-Engrave Part # and Batch # as per Dwg D350-748-141								
	4-Remove all marks from tube within limits of D350-748-141								
	5- Apply a light coat of LPS3 on the interior of tube Batch: _____								
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
	CHECK 10 DEG HOLES WITH DT8876E (EUROCOPTER CLAMP)								

See Attached
E-mail
→SAD
10-11-29
SAD
10-11-30

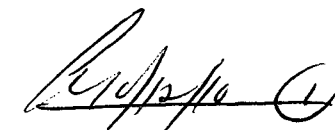
SAD 10/12/13

P10 on first
Page




Autosave - NDT issue P10 to accen

P10: 13113

CL 10/12/09 ①

Pack: ensure copy of NDT results rec'd
attached to W/O:

Dart Aerospace Ltd

W/O: 61765		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/12/09	175	NDT per QSI038 before + after load test per eng. this time only P/O: 13113	CL	10/12/09	1	 10/12/09		
		rec'd + inspect		11/12/10	1			

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Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Outsource process-Cadplate per QSI017 4.1.9.1

0.00



Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O:

13128

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

CY 10/12/14 ①

160

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

Carpenter ①

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SPM 2 81.875"

twist - 0.50" Issue P/O Accur LPI per ASTM 147 level 2 or LPI as per QSI038

P/O: 13367 CY 11/01/24 ①

rec'd + inspect + attached c/c to w/o

S 11/01/24 / 11/01/24

Carpenter

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180



SprayPaint

Spray Painting

SprayPaint

Memo

1-Prime inside crosstube as per QSI 005 4.2
2-Prime Outside of Tube as per Dart QSI 005 4.2

0.00

0.00

11-01-26

190



QC

Quality Control

QC14- Inspect Spray Paint

Memo

Then, Wrap in plastic bag to protect from scratches

0.00

0.00

11-01-27

200



Crosstubes

Crosstubes

Crosstubes

Memo

1-Install Ground wire Insert, then insert screw and washer
2-Install Abraison strips as per Dwg D350-748-141 & QSI 035.
3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

0.00

0.00

11-01-28

W/O:		WORK ORDER CHANGES					
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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sub 1/28

⑩

220

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/1/28 SP

230

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sub 1/31

⑩

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Required Date: 9/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D350-748-101

Location: 102PPP Rev: B

11/02/02 SP

250



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/02/02 JG

PL 11-02-1
①

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, September 02, 2010 11:18:38 AM

Page 1

Work Order ID: 61765

Parent Item: D350-748-101

Parent Item Name: Crosstube Installation, High Fwd

Start Date: 9/2/2010

Required Date: 9/20/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-07-05 JLM
 IPP Rev:B Update qty of MS21042L5 06-09-12 KJ
 IPP Rev:C Rev B 07-11-15 DD
 IPP Rev D Combined manufacturing 08.04.02 EC verified by: DD
 IPP Rev:E 08-06-24 revD as per dwg DD verified by:EC IPP Rev:F
 10.08.04 added QSI010 4.3 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-748-141TRN 		Manufactured	No			110	Each	0.0000	1				
Crosstube Turning Detail													
ALS4-1032-225 		Purchased	No			200	Each	5,336.000	1	1			
Insert													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				PK011		5336							
					110768	5336							
AN960JD10 	NAS1149D0363J	Purchased	No			200	Each	6.0000	1	1			
Washer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		6							
					107715	6							
D2856-400 		Manufactured	No			200	f	313.4060	1.181	1.243158			
Abraison Strip													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST403		313.4060421							
					56626	97.4060421							
					59920	216							

B61346

10-11-22

11-01-28

B#116025

11-01-28

11-01-28

B#63735

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Work Order ID: 61765



Parent Item: D350-748-101



Parent Item Name: Crosstube Installation, High Fwd

Start Date: 9/2/2010

Required Date: 9/20/2010

Start Qty: 1.00

Required Qty: 1.00

D3502-1

Manufactured No

200

Each

54.0000

2

2



Support



M 11-01-28

Location

Loc Qty

Loc Code

ST063

12

61206

12

ST066

42

~~50287~~

38

52903

4

MS21920-20

Purchased

No

200

Each

77.0000

2

2



M 11-01-28

Clamp (per MIL-DTL-8783C)

Location

Loc Qty

Loc Code

LG

77

112624

6

114687

21

114779

24

115057

26

B#115736

MS27039-1-10

Purchased

No

200

Each

126.0000

1

1



M 11-01-28

Screw

Location

Loc Qty

Loc Code

ST291

126

112794

26

112940

100

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Start Date: 9/2/2010

Required Date: 9/20/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-41A

Purchased

No

220

Each

274.0000

8 1 8



Bolt



ulike

Location

Loc Qty

Loc Code

ST337

40

ST360

234

111424

4

113359

30

114941

100

115108

100

AN4-6A

Purchased

No

220

Each

1,418.000

16 16



Bolt



ulike

Location

Loc Qty

Loc Code

ST356

1418

112933

96

113149

19

114523

2

114615

1

114941

500

115108

300

115457

500

AN5-32A

Purchased

No

220

Each

196.0000

4 4



Bolt



ulike

Location

Loc Qty

Loc Code

ST340

196

113121

4

114056

42

114405

50

115016

50

115108

50

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Start Qty: 1.00

Required Qty: 1.00

AN960JD416, NAS1149D0463J Purchased No

220

Each

0.0000

32 1 32

Washer

AN960JD516, NAS1149D0563J Purchased No

220

Each

34.0000

8 1 8

Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

D3500-1, Manufactured No

220

Each

30.0000

4 1 4

Saddle

Location

Loc Qty

Loc Code

ST424

30

55605

2

59422

16

60489

12

D3501-1, Manufactured No

220

Each

394.0000

16 1 16

Bushing

Location

Loc Qty

Loc Code

ST066

394

45402

15

45918

112

48268

67

53779

100

61196

100

Thursday, September 02, 2010 11:18:38 AM

Shop Packet Print

Page 4

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Required Date: 9/20/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

220

Each

2,379.000

24

24



Nut



M116548

11/1/20

[Signature]

Location

Loc Qty

Loc Code

ST300

2379

113422

68

114523

28

114718

16

114784

347

115108

1920

MS21042L5

Purchased

No

220

Each

633.0000

4

4



Nut



M116104

11/1/20 *[Signature]*

Location

Loc Qty

Loc Code

ST139

133

114813

133

ST300

500

115156

500

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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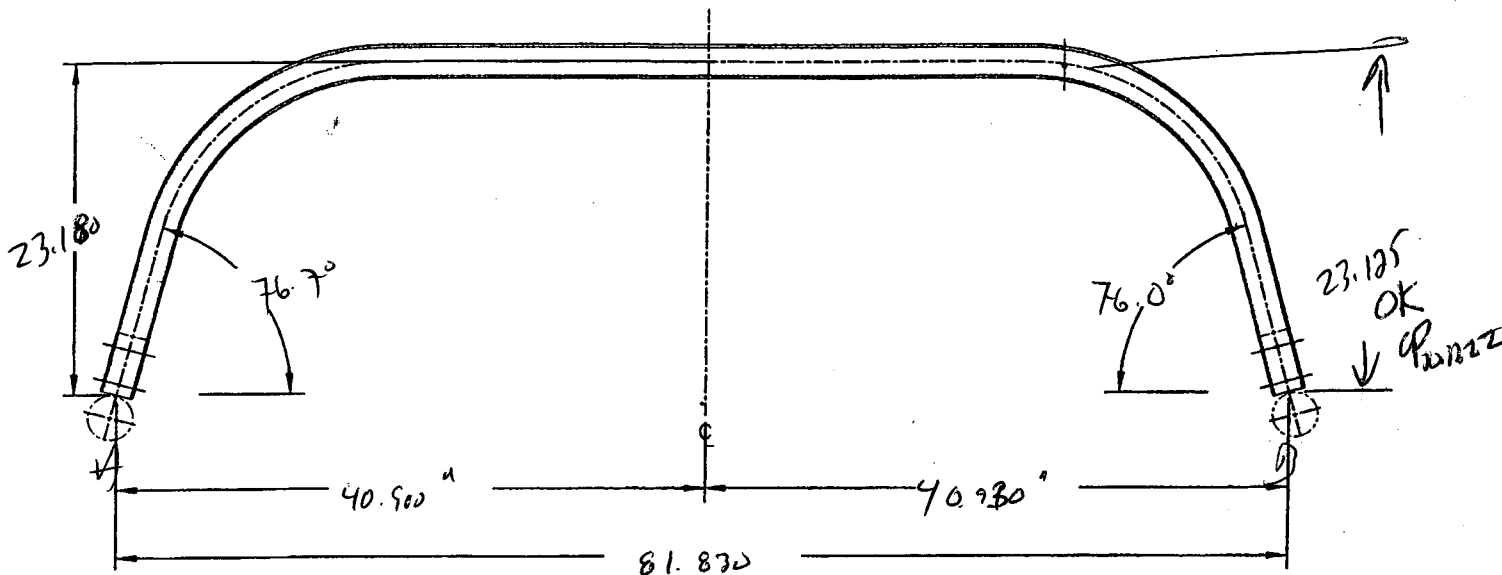
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41745
Description: Crosstube High Fwd (AS350/355)	Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: E		Page 1 of 1

Per SFD #120

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
twist 20.139" OK 10/11/22

QC15 Inspection	8
Date	10/14/22

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

10/14/23

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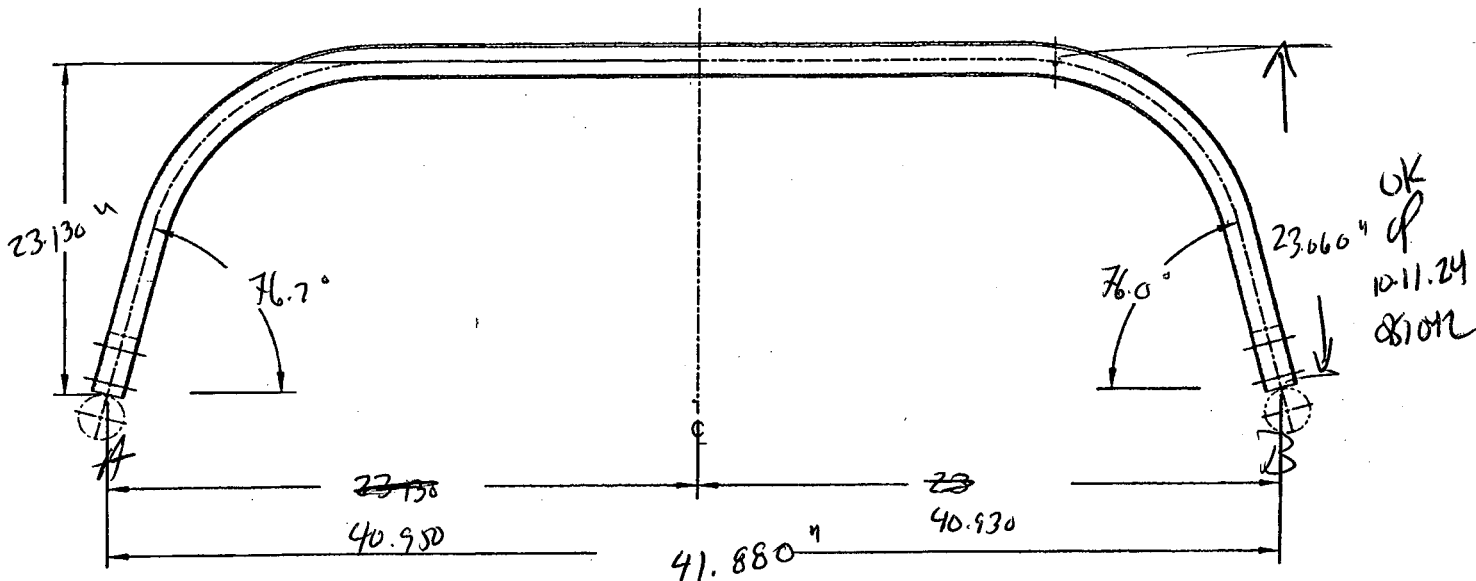
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141		Rev: E	Page 1 of 1

For Step #127

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
Twist = 0.126
measured after stress Relief

QC15 Inspection	S
Date	10/14/24

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

Item	Qty -141	Part Number	Description
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6017-115	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6017-115
FINISHED LENGTH = 110.270±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMEND.
WITHOUT NOTICE
WORK ORDER
NO. 44765
BS109-02

RELEASED
2009-10-29
JWP

E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D350-748-141	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

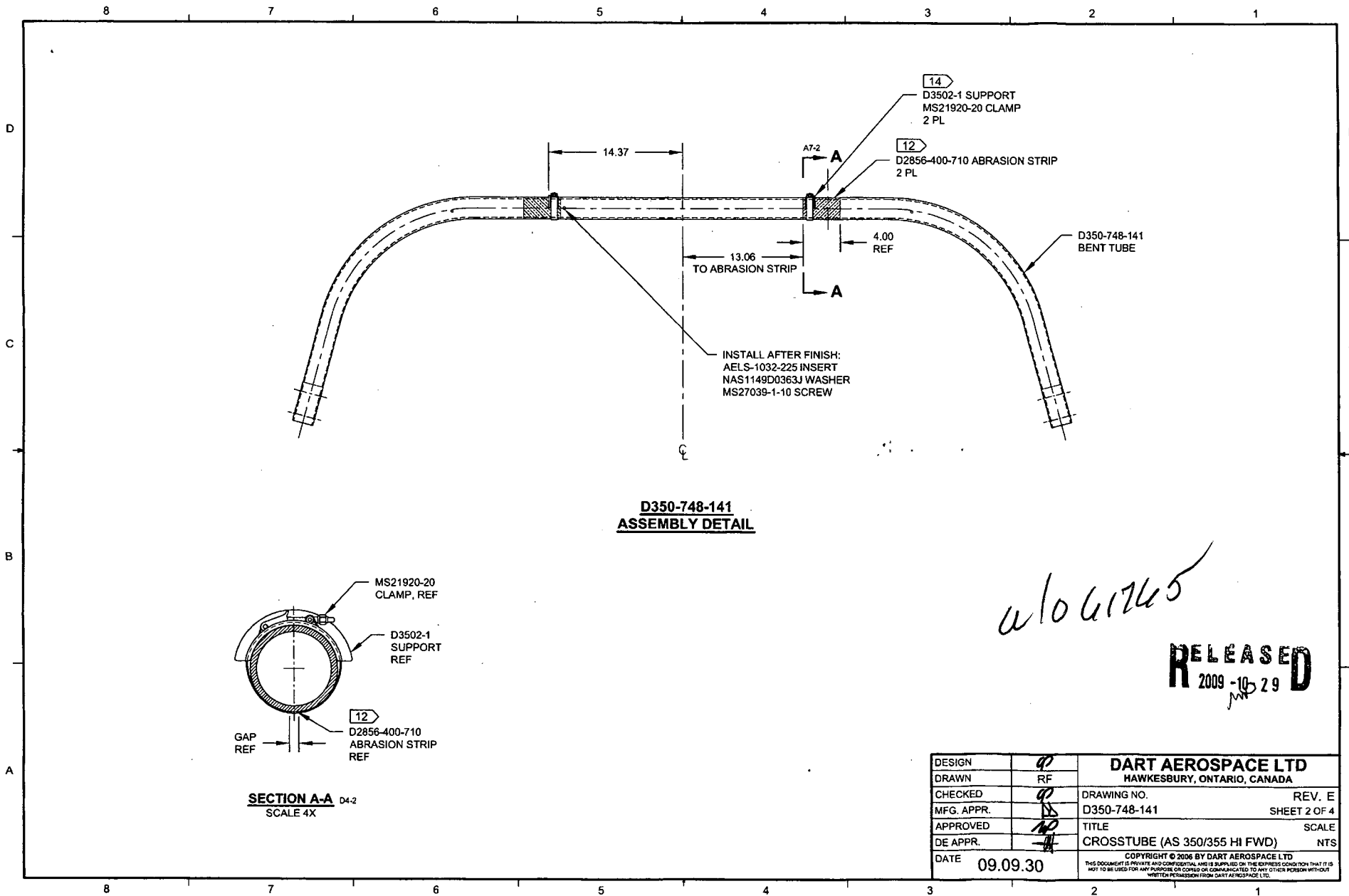
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



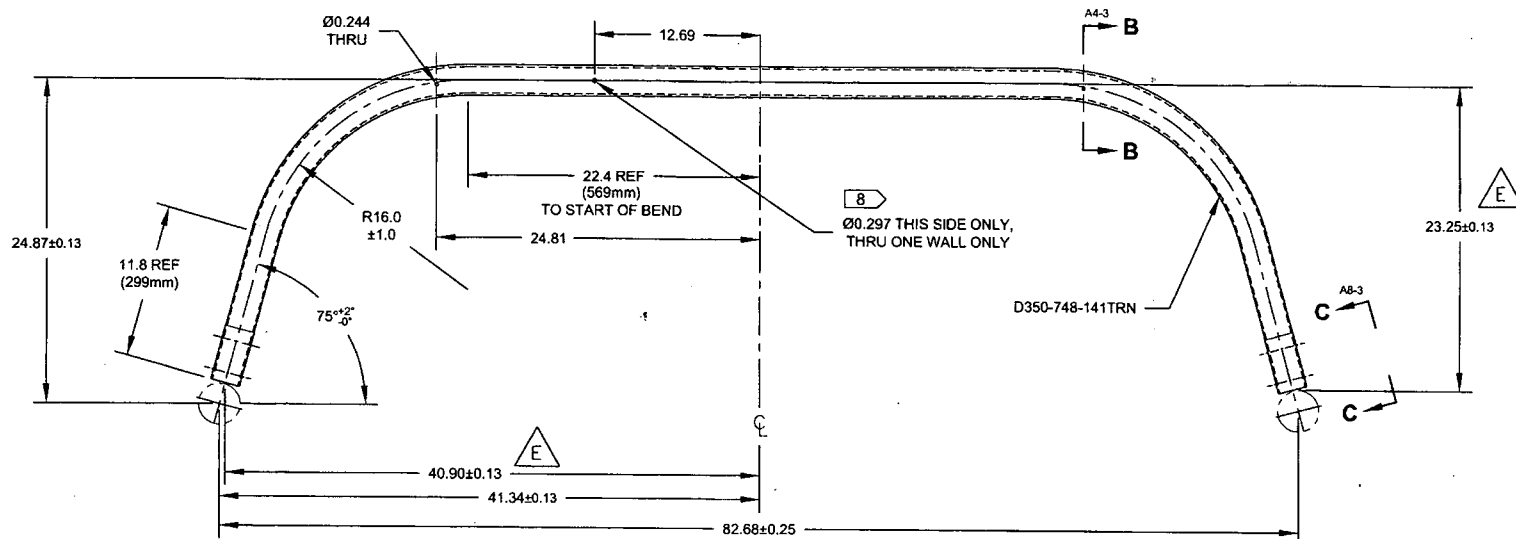
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod.Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

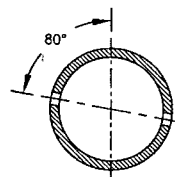
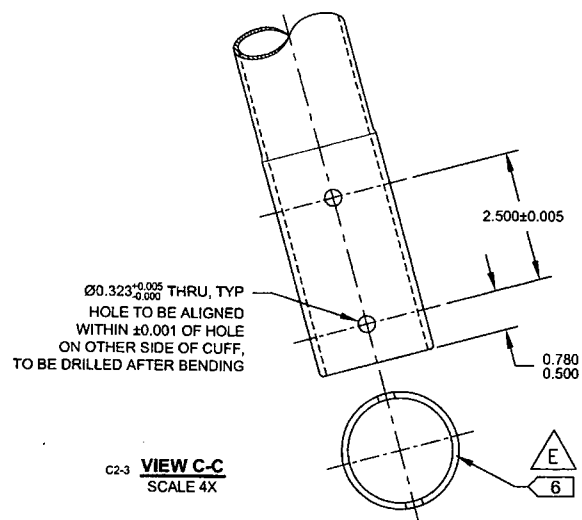
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-748-141
BENDING AND DRILLING DETAIL 10



SECTION B-B D3-3
 SCALE 4X

w/061745

RELEASED
 2009-10-29

DESIGN	97	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	97	D350-748-141	SHEET 3 OF 4
APPROVED	97	TITLE	SCALE
DE APPR.	97	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

L Lacelle

From: David Shepherd [dshepherd@dartaero.com]
Sent: May 11, 2010 12:37 PM
To: 'L Lacelle'; 'Mike Petsche'
Cc: 'Bill Beckett'; 'Chris Provencal'; 'Dan Stow'; ssheldon@dartaero.com; 'Chantal Lavoie'
Subject: RE: 350 crosstubes

Linda,

As discussed, if the tubes have been structurally tested, it has been documented on the work orders, and Chris has signed off on them, then it is acceptable to me to release the parts.

David

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Tuesday, May 11, 2010 8:37 AM
To: 'David Shepherd'; 'Mike Petsche'
Cc: 'Bill Beckett'; 'Chris Provencal'; 'Dan Stow'; ssheldon@dartaero.com; 'Chantal Lavoie'
Subject: RE: 350 crosstubes

Now that testing is done, can we ship out the batch that as been ready to heat treat?

LL

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: April 27, 2010 3:40 PM
To: 'Mike Petsche'
Cc: 'Bill Beckett'; 'L Lacelle'; 'Chris Provencal'; 'Dan Stow'; ssheldon@dartaero.com
Subject: 350 crosstubes

Mike,

I discussed the 350 crosstube load testing with Bill a little while ago and this plan makes sense to him.

So, my recommendation to clear these crosstubes is to load the fwd crosstubes to 3500 lb and the aft crosstubes to 3000 lb in the deflection test rig and document on the work orders that this test has been completed. Hold max load for 1 minute. Per TP-D350-748-2, these loads represent the maximum load on these crosstubes at gross weight and are below the yield point of the material. I would like to request that Chris Provencal witness these tests and sign off the work orders based on his experience with Dart landing gears. My feeling is that if there is a problem with the parts, it will manifest itself during this load test. I, for one, would feel a lot more confident in testing each crosstube in this manner than relying totally on what Exova has to say. I think it would be very difficult to reach a conclusion on the whole batch on the basis of cracks in two parts from the batch.

I believe that we can accomplish this before next Friday, which also gives us time to hear what Exova has to say in case it has an impact on our decision. So far, what I have seen from Exova shows me that there are fluctuations in the heat treating but the tubes are heat treated to our specification.

For this reason, I believe we should tell DHS that it looks like we will be able to start shipping 350 crosstubes by May 7th pending a successful Engineering test of the material.

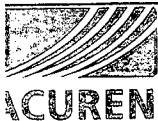
David.

No virus found in this incoming message.

Checked by AVG - www.avg.com

Version: 8.5.437 / Virus Database: 271.1.1/2865 - Release Date: 05/11/10 06:26:00

12/06/10



LIQUID PENETRANT TEST REPORT

P- 05492

PAGE 1 OF 1

TIME AM ☒ PM ☐CLIENT ART AEROSPACE DATE Dec 9/2010ATTENTION Wanda Kacelle / Maintenance ACUREN JOB NO. 183-10-C987ADDRESS 1270, HIBERDEN POWO NO.HALUKES BUILD, ON WORK LOCATION AS ADDRESSACCEPTANCE STD. ASIM 1417/CS 1038 REV./DATE 2008PROJECT Liquid Penetrant Inspection on "CRESTUBE" - HIGH AFTITEM(S) EXAMINED SEE W.O. # IN RESULTSJOB DESCRIPTION PROCEDURE NO. LT-003 REV./DATE 2008 TECHNIQUE NO. LT-003 REV./DATE 2008PART NO. MATERIAL AL-30 THICKNESS N/ASCOPE PERFORMED A Wet Flo Inspection BY LIQUID PENETRANT ON 100% OF THE EXTERNAL SURFACE

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	<u>MAC-DAF</u>		BLACK LIGHT S/N	<u>13790</u>	
PENETRANT	<u>ZK-67</u>	MINIMUM DWELL TIME	<u>10</u>	MIN.	<u>OUTPUT > 1000 μW/cm²</u>
PENETRANT REMOVER	<u>H-20</u>	MINIMUM DRY TIME	<u>>10</u>	MIN.	<u>OTHER</u>
DEVELOPER	<u>SKD-32</u>	MINIMUM DWELL TIME	<u>10</u>	MIN.	<u>OUTPUT > 100 fc @ SURFACE</u>
DEVELOPER TYPE	<input type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY	CAL DUE DATE <u>FEB 05 2011</u>	

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F	<input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☒ IMPERIAL)

#	ITEMS	RESULTS	ITEM ID
1	CRESTUBE - W.O. ID 63746	✓	NOTE: B=BEFORE DEFLECTION TEST A=AFTER DEFLECTION TEST
2	63747	✓	
3	63748	✓	ITEM ID: D350-748-201 (Items 1, 2, 3, 4)
4	63749	✓	
5	61763	✓	ITEM ID: D350-748-101 (Items 5, 6, 7, 8)
6	61764	✓	
7	61765	✓	ITEM ID: D3687-3 (MOUNTS)
8	61766	✓	
B	A & SEE NOTE →	✓	
ITEMS	ACC. 201		
SX MOUNTS - W.O. ID 61890	✓		

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE	<u>John Talley</u>	DTR # <u>EC3109</u>
TECHNICIAN (SIGNATURE):	<u>[Signature]</u>	REPORT REVIEWED BY:
NAME (PRINT):	<u>VES DESKES, JR</u>	NAME INITIALS
CGSB LEVEL <u>2</u> SNT LEVEL <u>2</u>	CGSB LEVEL <u>2</u> SNT LEVEL <u>2</u>	
CGSB REG. NO. <u>3049</u>	CGSB REG. NO. <u>3049</u>	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

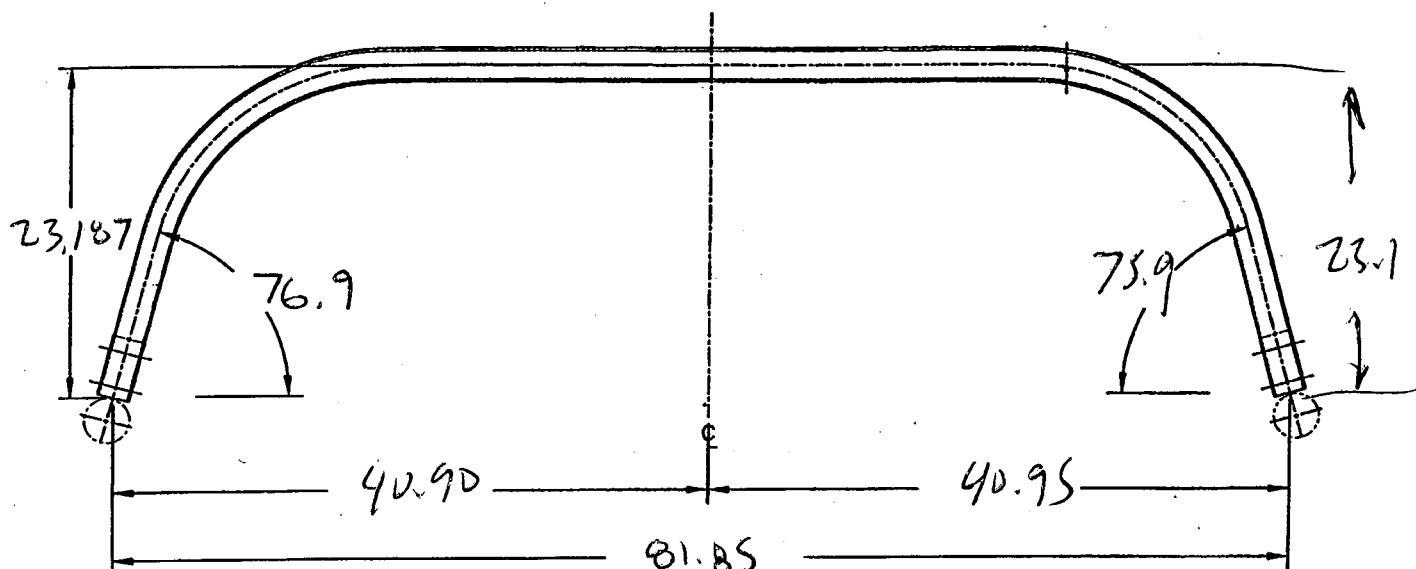
PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

PT Sept 2005

DART AEROSPACE LTD		Work Order:	6765
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments
FOLLOWING DEFLECTION TEST.
ACCEPTABLE P 10.12.09

QC15 Inspection	P 10.12.09
Date	10.12.09

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	10.08.23	Dwg Rev updated	KJ	

10.08.23

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Jan-14-2011

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St
Hawksbury, ON K6A 1K7

W/O #: 100753

INVOICE #: 52907

**CONTRACT OR
PURCHASE ORDER #**

PO13128

DESCRIPTION: SKID

QTY 1

P/N # d350-748-101

S/N # B61765

**STRESS RELIEF BAKE @375 DEG. BAKE HEAT CHART #10-1335.
MPI INSPECTED IAW ASTM-E-1444. CADMIUM PLATED IAW AMS-
QQ-P-416C, TYPE 2 YELLOW, CLASS 1. BAKE HEAT CHART #11-5.**

8 u101/24

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:



A large, stylized handwritten signature in black ink.



RAPPORT D'INSPECTION NON DESTRUCTIVE

(SUITE)

REPORT# P-05496

PAGE 2 DE 2

CLIENT DART AEROSPACE DATE JAN/26/2011 HEURE ☒ AM ☐ PM
ATTENTION LINDA LACELLE / CHARITKE / IAN ACUREN W/O : 188-11-02103

RÉSULTATS ☐ MÉTRIQUE ☒ IMPÉRIALE

ITEM	COMMENTS	ACCEPT	REJECT	ITEM ID
8	CROSS TUBE W.O. ID 61763	✓		ITEM ID: D350-748-101(H.F.)
9	CROSS TUBE W.O. ID 61764	✓		D350-748-101(H.F.)
10	CROSS TUBE W.O. ID 61765	X		D350-748-101(H.F.)
11	CROSS TUBE W.O. ID 61766	✓		D350-748-101(H.F.)
12	CROSS TUBE W.O. ID 61767	✓		D350-748-201(H.A.)
13	CROSS TUBE W.O. ID 61768	✓		D350-748-201(H.A.)
14	CROSS TUBE W.O. ID 61769	✓		D350-748-201(H.A.)
15	CROSS TUBE W.O. ID 61770	✓		D350-748-201(H.A.)

BT 11-01-20

— NO REJECTABLE INDICATION WAS DETECTED, AS PER APPLICABLE STANDARD

Étendue des services

L'entente selon laquelle le Groupe Acuren Inc. exécute les services ne concerne que les énoncés par écrit. En aucune circonstance ces services ne s'étendent au-delà de l'exécution des services demandés. Il est entendu que toutes les descriptions, les observations et les expressions d'opinions faites par Acuren reflètent les opinions ou les observations de l'entreprise fondées sur l'information et les hypothèses fournies par le propriétaire/opérateur, et elles ne constituent pas des déclarations ou des garanties ou ne peuvent être interprétées comme constituant. Le groupe Acuren Inc. n'assume aucune des responsabilités du propriétaire/opérateur, et le propriétaire/opérateur conserve la responsabilité entière des décisions prises en matière d'ingénierie, de fabrication, de réparation et d'usage à partir de l'information ou des données fournies par Acuren en rapport avec les services décrits dans les présentes ne peuvent excéder le coût des services rendus.

Norme de Diligence

Dans l'exécution des services, le Groupe Acuren Inc. applique le degré de diligence, le soin et la compétence normalement exercés dans des circonstances semblables par d'autres fournisseurs de ce type de services opérant dans la même localité ou dans une localité similaire. Aucune autre garantie, implicite ou explicite, n'est faite ou voulue par le Groupe Acuren Inc.

SIGNATURES

REPRÉSENTANT CLIENT	<u>Bar Titley</u>	FTJ#: <u>663121</u>
TECHNICIEN (SIGNATURE):	<u>[Signature]</u>	RAPPORT
NOM (MOULIÉ):	<u>WES DESBIERS</u>	REVISÉ PAR:
		NOM
		INITIALES
ONGC NIVEAU <u>2</u> SNT NIVEAU <u>2</u>	ONGC NIVEAU <u>—</u> SNT NIVEAU <u>—</u>	
ONGC N° REGISTRATION <u>3049</u>	ONGC N° REGISTRATION <u>—</u>	

5.0 PARTS LIST

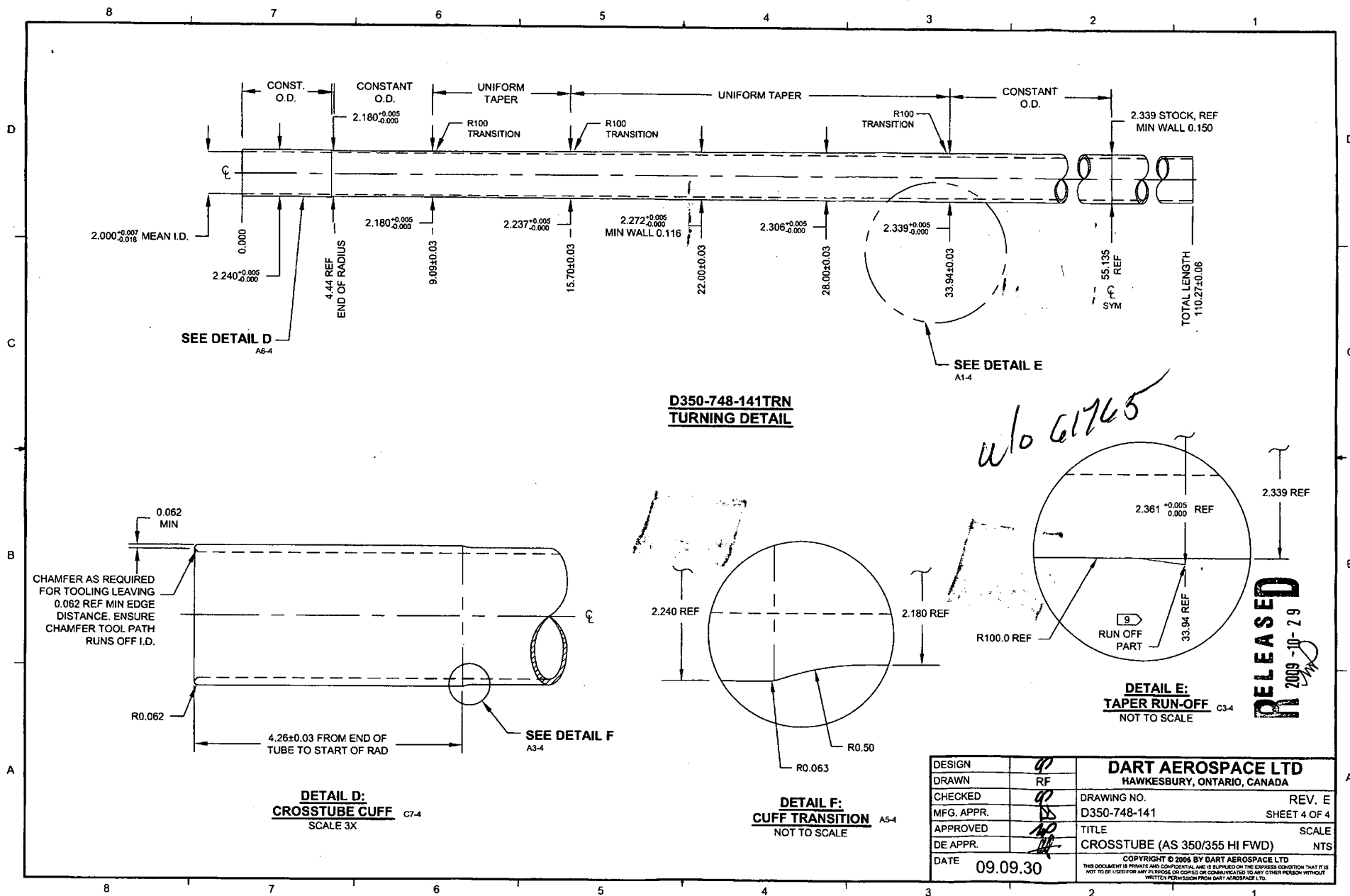
Qty -101	Qty -201	Part Number	Description
X		D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1		D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1	D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
*2	*2	D3502-1	SUPPORT
*2	*2	D2856-400-710	ABRASION STRIP
*1	*1	AELS-1032-225	INSERT
*2	*2	MS21920-20	CLAMP
*1	*1	MS27039-1-10	SCREW
*1	*1	AN960JD10	WASHER
4	4	D3500-1	SADDLE
16	16	D3501-1	BUSHING
16	16	AN4-6A	BOLT
8	8	AN4-41A	BOLT
4	4	AN5-32A	BOLT
32	32	AN960JD416	WASHER
8	8	AN960JD516	WASHER
24	24	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

* REFERENCE ONLY. PARTS ARE INCLUDED IN D350-748-141/241 ASSEMBLIES ABOVE

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Revision: **B**
Date: 07.06.15



DESIGN	QF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	QF	DRAWING NO.	REV. E
MFG. APPR.	AS	D350-748-141	SHEET 4 OF 4
APPROVED	AD	TITLE	SCALE
DE APPR.	AD	CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	09.09.30	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries